



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D130-1048-042
Job Sheet 196766



Part No: D130-1048-042

Job Qty: 1 pcs

Part Name: H130/EC130 - Replacement Skidtube - Standard - RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/20/19

Job Tracking No:

Due Date: 7/12/19 *July 28*

Created By: Marie Lajeunesse

Type: ~~SOLD~~ *SHT*

Description:

Note: DWG D130-1048-042 REV.B/ IIN-D130-1048 REV.C IPP REV:A 18.08.15 new issue DP Verify DD

Ship Via:

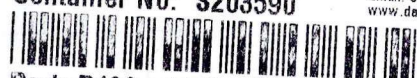
Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
150	Skidtubes - 1	1 pcs	7/12/19		0.00	2.00	Skidtubes - 1		
							Skidtubes - 2		
							Skidtubes - 3		<i>mba</i>
							Skidtubes - 4		
							Skidtubes - 5		
							Skidtubes - 6		
							Skidtubes - 7		
160	QC 5	1 pcs	7/12/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
162	Handfinish - 1-1 Chemical-B4B	1 pcs	7/12/19		0.00	0.33	Handfinish - 1 - 1 - B4B		
							Handfinish - 1 - 2 - B4B		
							Handfinish - 1 - 3 - B4B		
							Handfinish - 1 - 4 - B4B		
							Handfinish - 1 - 5 - B4B		
							Handfinish - 1 - 6 - B4B		
							Handfinish - 1 - 7 - B4B		



Container No: S203590



Part: D130 - 1048 - 042

Job No: 196766

Serial No/Batch: S203590

Revision: B/C

Inspector:

Exp Date:

Instructions: TC STC SH19 - 4 Issue 1, FAA STC SR04320N

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CANADA
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68
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					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
164 QC 7	1 pcs	7/12/19	0.00 0.00		QC 7 - 10	
					QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	19-8-10
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
166 Outsource - 2 - NDT per QSI038	1 pcs	7/12/19			SKY002-VC	5
170 Packaging 2-1 - Receive - B4B	1 pcs	7/12/19	0.00 0.00		Packaging 2 - 1 - B4B	
					Packaging 2 - 2 - B4B	
					Packaging 2 - 3 - B4B	
					Packaging 2 - 5 - B4B	

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				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
180 QC 6	1 pcs	7/12/19	0.00 0.00	QC 6 - 9	
				QC 6 - 68	
				QC 6 - 61	
				QC 6 - 40	
182 Spray Paint - 2 - B4B	1 pcs	7/12/19	0.00 1.00	Spray Paint - 1 - B4B	
				Spray Paint - 2 - B4B	
				Spray Paint - 3 - B4B	
				Spray Paint - 4 - B4B	
184 QC 14	1 pcs	7/12/19	0.00 0.00	QC 14 - 15	
				QC 14 - 2	
				QC 14 - 34	
				QC 14 - 41	
				QC 14 - 51	
				QC 14 - 58	
				QC 14 - 59	
				QC 14 - 9	
				QC 14 - 68	
				QC 14 - 40	
				QC 14 - 19	
				QC 14 - 43	
				QC 14 - 24	
200 Handfinish - 4-1-Assembly-B4B	1 pcs	7/12/19	0.00 1.00	Handfinish - 4 - 1 - B4B	
				Handfinish - 4 - 10 - B4B	
				Handfinish - 4 - 11 - B4B	
				Handfinish - 4 - 12 - B4B	

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DAS
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9-89

AUG 14 2019

A 19-8-15

						Handfinish - 4 - 13 - B4B					
						Handfinish - 4 - 14 - B4B					
						Handfinish - 4 - 15 - B4B					
						Handfinish - 4 - 2 - B4B					
						Handfinish - 4 - 3 - B4B					
						Handfinish - 4 - 4 - B4B					
						Handfinish - 4 - 5 - B4B					
						Handfinish - 4 - 6 - B4B					
						Handfinish - 4 - 7 - B4B					
						Handfinish - 4 - 8 - B4B					
						Handfinish - 4 - 9 - B4B					
						220 QC 5	1 pcs	7/12/19	0.00	0.00	QC 5 - 10
QC 5 - 12											
QC 5 - 17											
QC 5 - 18											
QC 5 - 19											
QC 5 - 22											
QC 5 - 24											
QC 5 - 3	DAS										
QC 5 - 43	19										
QC 5 - 49	9-89										
QC 5 - 51											
QC 5 - 58											
QC 5 - 68											
QC 5 - 9											
QC 5 - 50											
QC 5 - 30											
QC 5 - 40											
230 Spray Paint - 3 - B4B	1 pcs	7/12/19	0.00	0.50	Spray Paint - 1 - B4B						• AB 19-8-16
					Spray Paint - 2 - B4B						
					Spray Paint - 3 - B4B						
					Spray Paint - 4 - B4B						
240 QC 14	1 pcs	7/12/19	0.00	0.00	QC 14 - 15	ML 19-8-21					
					QC 14 - 2						
					QC 14 - 34						
					QC 14 - 41						
					QC 14 - 51						
					QC 14 - 58						
					QC 14 - 59						
					QC 14 - 9						
					QC 14 - 68						
					QC 14 - 40						
					QC 14 - 19						
					QC 14 - 43						
					QC 14 - 24						
260 Handfinish - 4-2-Assembly-B4B	1 pcs	7/12/19	0.00	0.17	Handfinish - 4 - 1 - B4B	ML 19-8-21					
					Handfinish - 4 - 10 - B4B						
					Handfinish - 4 - 11 - B4B						
					Handfinish - 4 - 12 - B4B						
					Handfinish - 4 - 13 - B4B						
					Handfinish - 4 - 14 - B4B						
					Handfinish - 4 - 15 - B4B						

Plex 6/20/19 1:32 PM Dart.lajeunesse.marie

265 QC 5	1 pcs	7/12/19	0.00 0.00	Handfinish - 4 - 2 - B4B	
				Handfinish - 4 - 3 - B4B	
				Handfinish - 4 - 4 - B4B	
				Handfinish - 4 - 5 - B4B	
				Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	DAG
				QC 5 - 49	19
				QC 5 - 51	9-00
270 Packaging 3-1 - Stock - B4B	1 pcs	7/12/19	0.00 0.00	QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	ul 14-8-22
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	

				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	DAS
280 DC - 1 - B4B	1	7/12/19	0.00 0.00	DC - 1 - B4B	21 AUG 22 2019
	pcs			DC - 2 - B4B	9-85
290 QC 21 - FG	1	7/12/19	0.00 0.00	QC 21 - FG - 21	
	pcs			QC 21 - FG - 70	DAS AUG 22 2019
				QC 21 - SA - 53	21

Part Op 150 - 1-Remove bending marks longitudinally. ***Use Linemate*** 2-Identify as per note 6. 3-Insert skidtube in DT10416-Descriptions: B, position tube so that bend sect. rest against DT10448B. Bottom out FWD end against DT10448C. Use clamp to hold tube. ***BEND SECT. AND SADDLE MUST BE WITHIN 1 DEGREE OF TUBE C/L.*** Drill all pilot holes. Cleco as you drill. 4-Open holes to finish size at section B-B, C-C and D-D 5- Cleco D5571-1 saddle in previously drilled pilot holes. Transfer drill remaining saddle holes into D5611-1 skidtube. Open holes to finish size. ***SEE NOTE 11, SHEET 1, THESE ARE THE ONLY TWO HOLES THAT CAN NOT BE OPEN TO SIZE*** *****SADDLE MUST BE IDENTIFY WITH SKIDTUBE***** 6-Cleco DT10432 on two previously drilled FWD wear plate holes and drill remaining four FWD wear plate holes (SECT. E-E) Cleco DT10439 on two previously drilled AFT wear plate holes and drill remaining four AFT wear plate holes (SECT. C-C) . 7-Open holes section C-C, D-D and E-E to finished size. 8-Chamfer AFT end of tube as per DWG sheet 2 note 8. 9-Chamfer FWD end of tube as per DWG sheet 2 note 9. 10-Open blade fitting holes and deburr as per note 5. Test fit blade fitting.

160 - (QC5- Inspect part completeness to step on W/O)

164 - (QC7-Inspect Chemical Conversion Coat)

166 - (Outsource process - NDT per QSI038 4.1), ISSUE P/O: _____ Liquid Penetrant Inspection as per QSI 038 LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order NDT C OF C IS REQUIRED

170 - (Receive & Inspect for Damage & Mat'l Certs), Ensure copy of NDT results attached to work order.

180 - (QC6- All purchased or subcontracted products)

182 - PRIME AREA SHOWN (TO 1.0 BELOW CENTERLINE), PER DART QSI 005 4.2.1.3.3 (FLOAT SKIDTUBE PRIMER) BATCH: 5199127

184 - (QC14- Inspect Spray Paint)

200 - (Assemble as per dwg), 1-Wet install and seal faying surface saddle with Maxibolt rivets as per DWG sheet 1 note 8 and 9 ***EXCEPT THE TWO TOP HOLES.*** Pro Seal 890 B 517600 EXP 19/10 ***VERY IMPORTANT TO LET A 12HR CURE TIME*** 2- As per note 11 on sheet 1. Open the top remaining holes to size, use #8 drill (0.199") 3-Touch up Alodine the two holes with ALODINE 600 4- Install the two remaining Maxibolt rivets as per dwg 5-Shave rivets as required. 6-Remove chips from inside of tube and clean tube. Prepare for final inspection. 7- FILLET SEAL ALL AROUND SADDLE WITH OR PROSEAL 890 OR EQUIVALENT MIL-S-8802 CLASS B SEALANT

220 - (QC5- Inspect part completeness to step on W/O)

230 - 1-Prime inside & outside cross tube as per DWG sheet1 note 2 and QSI 005 4.2.1.3.3 BATCH: 5199127 ***NOTE***do not paint inside saddle bore. Primer only. 2-Paint Outside of Tube as per DWG sheet 1 note 2 and Dart QSI 005 4.2.2.4 BATCH: 5204428

240 - (QC14- Inspect Spray Paint)

260 - (Assemble as per dwg), Install inserts as per DWG sheet 1 note 10.

265 - (QC5- Inspect part completeness to step on W/O)

270 - (Identify as per dwg & Stock Location: _____), Identify and pack for shipping as per PPP D130-1048-042

Location: _____ PPP Rev: _____

280 - Photocopy blue file & type labels per PPP D130-1048-042 CHG001

290 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D5571-1	Saddle	1 pcs (1 ea)	150-Skidtubes - 1	5200878
D5611-1	EC130 Skidtube	1 pcs (1 ea)	150-Skidtubes - 1	5167514
CR7621S-06-05	Rivet +2 Scraps	22 Ea (22 ea)	200-Handfinish - 4-1-Assembly-B4B	5108055
ALS4-1032-225	Rivnut	8 Ea (8 ea)	260-Handfinish - 4-2-Assembly-B4B	5134309

Job Allocations

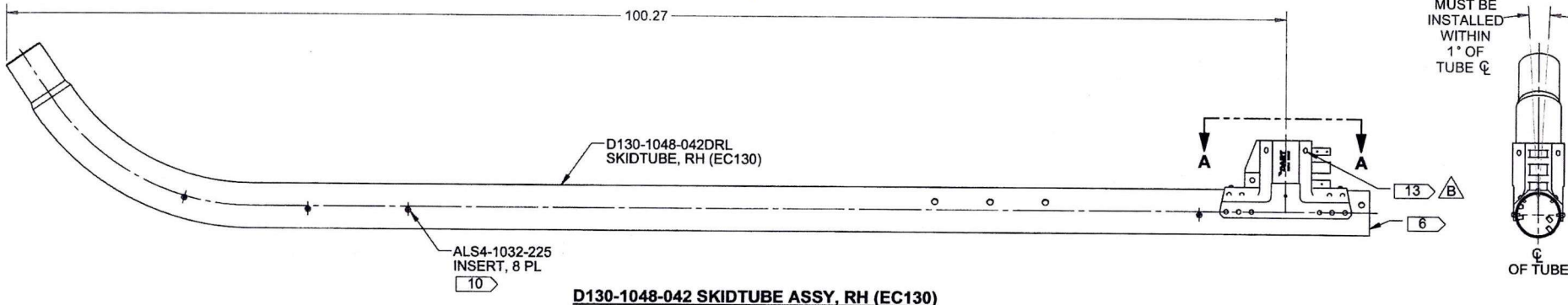
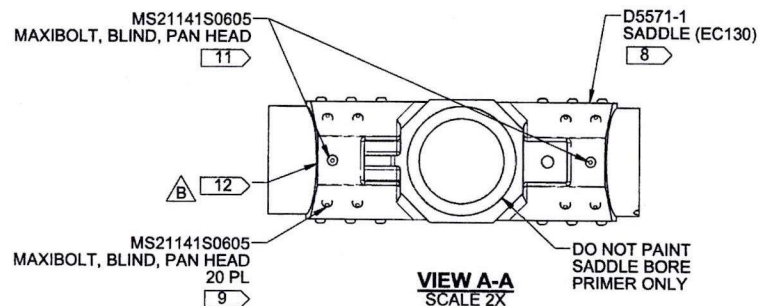
Operation	Component Part	Required	Inventory	Allocated
150-Skidtubes - 1	D5571-1	1	0	0
	D5611-1	1	14	0
200-Handfinish - 4-1-Assembly-B4B	CR7621S-06-05	22	209	0
260-Handfinish - 4-2-Assembly-B4B	ALS4-1032-225	8	1,069	0

Part Specifications

Specifications could not be found.

QTY -042	P/N	DESCRIPTION
X	D130-1048-042	SKIDTUBE ASSY, RH (EC130)
1	D130-1048-042DRL	SKIDTUBE, RH (EC130)
1	D5571-1	SADDLE (EC130)
22	MS21141S0605	MAXIBOLT, BLIND, PAN HEAD
8	ALS4-1032-225	INSERT

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 196766 MW
140020



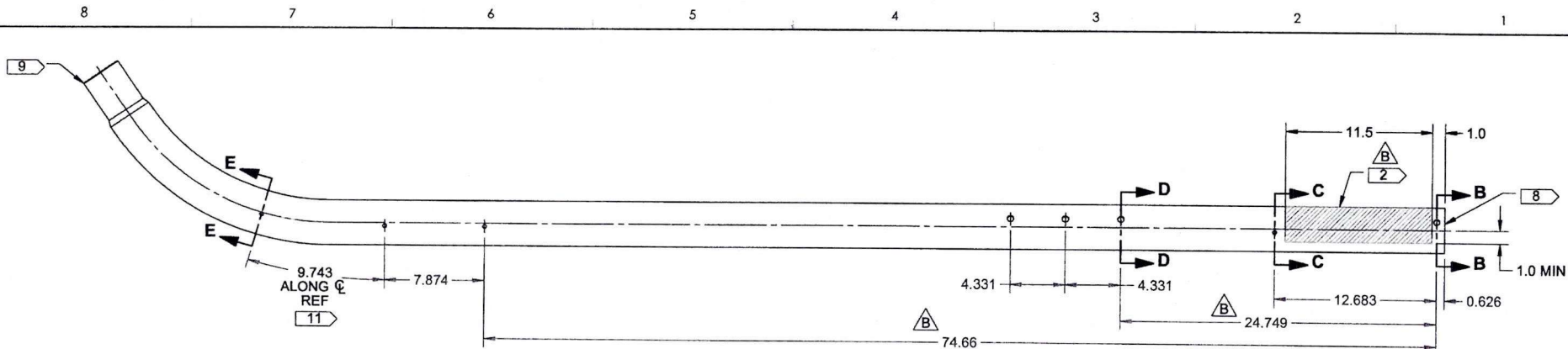
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2.1.3.3 (FLOAT SKIDTUBE PRIMER) AFTER ASSEMBLY
PAINT OUTSIDE PER DART QSI 005 4.2.2.4 (FLOAT SKIDTUBE PAINT) AFTER ASSEMBLY
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D130-1048-042" AND S/N PER DART QSI 044 6.4
ON INSIDE OF TUBE, MAX 0.5" FROM AFT END OF TUBE
- 7) WEIGHT: 20.29 lbs
- 8) SEAL FAYING SURFACE WITH PROSEAL 890 OR EQUIVALENT MIL-S-8802 CLASS A SEALANT
- 9) POSITION SADDLE AND TRANSFER DRILL $\phi 0.193$ HOLE PATTERN FROM SADDLE ONTO SKIDTUBE.
OPEN HOLES THRU SADDLE AND SKIDTUBE TO $\phi 0.199 - \phi 0.202$. TOUCH-UP HOLES WITH CHEMICAL FILM (ALODINE 1200)
PER MIL-DTL-5541. WET INSTALL MAXIBOLTS WITH PROSEAL 890 OR EQUIVALENT MIL-S-8802 CLASS A SEALANT
- 10) INSTALL ALS4 INSERTS IN EXISTING $\phi 0.297$ HOLES AFTER FINISH
- 11) TRANSFER DRILL $\phi 0.193$ HOLES FROM SADDLE TO SKIDTUBE. OPEN HOLES THRU SADDLE AND SKIDTUBE
TO $\phi 0.199 - \phi 0.202$. ENSURE CLEAN HOLES FOR GOOD ELECTRICAL BONDING. TOUCH-UP HOLES WITH
ELECTRICALLY CONDUCTIVE CHEMICAL FILM (ALODINE 600) PER MIL-DTL-5541. INSTALL MAXIBOLTS DRY (NO SEALANT).
- 12) FILLET SEAL ALL AROUND SADDLE WITH SIKAFLEX-241/-291 OR PROSEAL 890 OR EQUIVALENT MIL-S-8802 CLASS B SEALANT
- 13) MASK SADDLE HOLES BEFORE PRIME AND PAINT

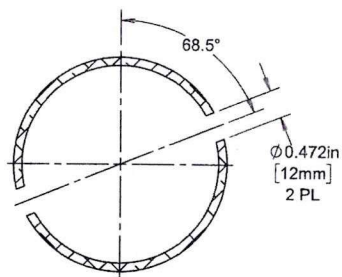
RELEASED

2019 JUN 13 NO
ECN 19-625

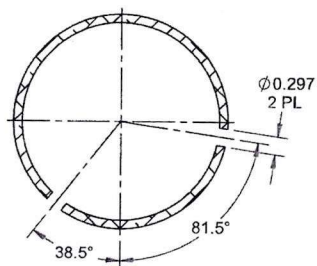
B	REDRAWN BOTH SHEETS, D130-1048-042: ADDED PRIME TO FINISH NOTE, ADDED CLASS A SEALANT FOR FAY SEAL AND WET INSTALL MAXIBOLTS, INSTALL ALS4 INSERTS AFTER FINISH, ADDED NOTE 12. D130-1048-042DRL: PRIME IN AREA SHOWN WAS PRIME INSIDE AND OUTSIDE, LPI AFTER DRILLING WAS PRIOR TO DRILLING, ADDED NOTE 12, REDIMENSION FROM BLADE HOLE INSTEAD OF TUBE END.	ZF	18.12.31
A	NEW ISSUE	ZF	18.05.07
REV.	DESCRIPTION	BY	DATE
DESIGN	NO	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ZF	DRAWING NO. D130-1048-042	
CHECKED	MW	REV. B	
MFG. APPR.	JFS	SHEET 1 OF 2	
APPROVED	NO	TITLE SKIDTUBE ASSY, RH (EC130)	
DE APPR.	CP	SCALE NTS	
DATE	18.12.31	COPYRIGHT © 2018 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



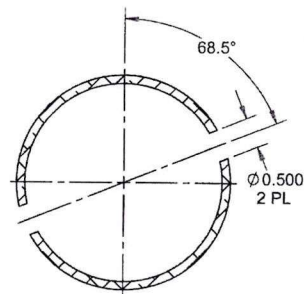
D130-1048-042DRL SKIDTUBE, RH (EC130)
(DRILLING DETAIL)



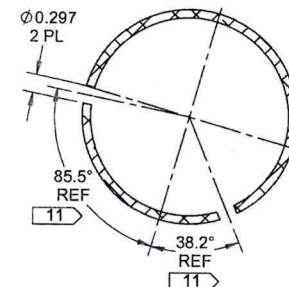
SECTION B-B
SCALE 4X



SECTION C-C
SCALE 4X, 3 PL



SECTION D-D
SCALE 4X, 3 PL



SECTION E-E
SCALE 4X

NOTES:

- 1) MATERIAL: MAKE FROM D5611-1
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME AREA SHOWN (TO 1.0 BELOW CENTERLINE), PER DART QSI 005 4.2.1.3.3 (FLOAT SKIDTUBE PRIMER)
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 16.34 lbs
- 8) CHAMFER ID 0.06X0.06 WHERE INDICATED
- 9) CHAMFER OD 0.06X0.06 WHERE INDICATED
- 10) LIQUID PENETRANT INSPECT OUTSIDE SURFACE PER QSI 038 AFTER DRILLING.
- 11) LOCATE HOLES USING DRILLING JIG DT10432.
- 12) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE.
THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, WRINKLES, OR DENTS.
DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.

RELEASED

2019 JUN 19 No

APPROVED

DESIGN NO
DRAWN ZF
CHECKED MW
MFG. APPR. JFS
APPROVED NO
DE APPR. CP
DATE 18.12.31

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA
DRAWING NO. D130-1048-042
REV. B
SHEET 2 OF 2
TITLE SKIDTUBE ASSY, RH (EC130)
SCALE NTS

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044239



Supplier: SKY002-VC
Skyservice
6120 Midfield Road
Mississauga
ON
L5P 1B1 Canada
Phone: 905-678-5636
Fax: 905-678-5841

Attention: Jenne, Heather

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044239

PO Date: 8/12/19

Due Date: 8/13/19

**Purchase Order
Revision:**

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pynt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	197937	D119-796-251	Aft Crosstube Installation With Step (No Hardware) : TC STC SH14-45-Issue 1, FAA STC SR03504NY 15/01/28, EASA STC 10052022 Revision 1 15/02/13, DGCA INDIA LoA 07-09/2011-AED (Part) 15/07/16, BRAZIL STC 2015S07-16 15/07/30, CAAP PHILIPPINES LoA 16/05/11, CHINA VSTC0757 16/07/22, RUSSIA STC CT316-A119 16/08/11, DGAC INDONESIA STC SR025 18/02/19 ISSUE P/O: *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** C OF C IS REQUIRED	Firmed	-	8/13/19	1 pcs	0 pcs	1 pcs	\$119.50/pcs	\$119.50
	197938			Firmed	-	8/13/19	1 pcs	0 pcs	1 pcs	\$119.50/pcs	\$119.50
Sub Total:							2	0	2		\$239.00



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PURCHASE ORDER

POHB044239



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
2	197723	D206-667-203	Aft Crosstube - High 206L / L1 / L3 / L4 : TC STC SH01-5 Issue 3, FAA STC SR01304NY 05/12/15, JCAB JAPAN STC-32-OSA 02/02/28, EASA STC EASA.IM.R.S.01179 06/07/03, BRAZIL 2009S08-16 09/08/25, BRAZIL 2009S08-17 09/08/25 (Outsource process - NDT per QSI038 4.1), *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Issue P/O: _____ LPI as per ASTM 1417	Firmed	-	8/13/19	1 pcs	0 pcs	1 pcs	\$119.50/pcs	\$119.50
	197724			Firmed	-	8/13/19	1 pcs	0 pcs	1 pcs	\$119.50/pcs	\$119.50
Sub Total:							2	0	2		\$239.00
3	197725	D206-667-201	Aft Crosstube - High 206 A/B : TC STC SH01-5 Issue 3, FAA STC SR01304NY 05/12/15, JCAB JAPAN STC-32-OSA 02/02/28, EASA STC EASA.IM.R.S.01179 06/07/03, BRAZIL 2009S08-16 09/08/25, BRAZIL 2009S08-17 09/08/25 (Outsource process - NDT per QSI038 4.1), *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***	Firmed	-	8/13/19	1 pcs	0 pcs	1 pcs	\$119.50/pcs	\$119.50
	197726			Firmed	-	8/13/19	1 pcs	0 pcs	1 pcs	\$119.50/pcs	\$119.50
Sub Total:							2	0	2		\$239.00
4	196763	D130-1048-041	H130/EC130 - Replacement Skidtube - Standard - LH : TC STC SH19-4 Issue 1, FAA STC SR04320NY dated 19/03/26 (Outsource process - NDT per QSI038 4.1), ISSUE P/O: _____ Liquid Penetrant Inspection as per QSI 038 LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order NDT C OF C IS REQUIRED	Firmed	-	8/13/19	1 pcs	0 pcs	1 pcs	\$119.50/pcs	\$119.50
	196762			Firmed	-	8/13/19	1 pcs	0 pcs	1 pcs	\$119.50/pcs	\$119.50
Sub Total:							2	0	2		\$239.00



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044239



DAS
40
8-89

Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
5	196766	D130-1048-042	H130/EC130 - Replacement Skidtube - Standard - RH : TC STC SH19-4 Issue 1, FAA STC SR04320NY dated 19/03/26 (Outsource process - NDT per QSI038 4.1), ISSUE P/O: Liquid Penetrant Inspection as per QSI 038 LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order NDT C OF C IS REQUIRED	Firmed	-	8/13/19	1 pcs	0 pcs	1 pcs	\$119.50/pcs	\$119.50
	196767			Firmed	-	8/13/19	1 pcs	0 pcs	1 pcs	\$119.50/pcs	\$119.50
Sub Total:							2	0	2		\$239.00
Grand Total:										\$1,195.00	

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

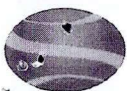
A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 8/13/19 1:55 PM Dart.Guerin.Kimberley

**skyservice****Work Order Traveler**

Sky Service F.B.O. Inc.

10105 Ryan Avenue, Dorval, Quebec, H9P 1A2

TCCA AMO 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO41392	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: POHB044239 ✓
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN:	CSN:	TSO:	
Task: UNSCHEDULED			Sequence: 1

Work Required:**CARRY OUT NDT ON:**

✓ 2 REPLACEMENT SKIDTUBE-STANDARD-LH , P/N: D130-1048-041 , J/S: 196762 , 196763

✓ 2 REPLACEMENT SKIDTUBE-STANDARD-RH , P/N: D130-1048-042 , J/S: 196766 , 196767

✓ 2 AFT CROSSTUBES , P/N D119-796-251 , J/S: 197937 , 197938

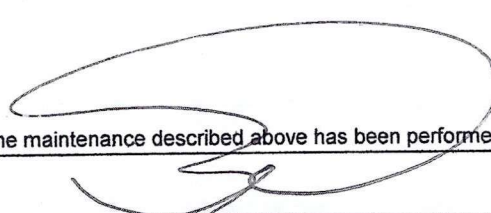
✓ 2 AFT CROSSTUBES , P/N: D206-667-203 , J/S: 197723 , 197724

✓ 2 AFT CROSSTUBES , P/N: D206-667-201 , J/S: 197725 , 197726

DA
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9-8

Action Taken:						Date:	Initial/Stamp:
LPI C/O IAW ASTM E-1417M-16 NO CRACK FOUND PEN. ZL-56, MPO13600, CLEANER SKC-S MPO13923 , DEV. MPO11715 , UV LIGHT M-20142						AUG 13 2019	 
Description	Location	P/N	Qty	Batch	S/N Off	S/N On	

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature: 	ACA/SCA Stamp 	Date: AUG 13 2019
Name: RAFIK MELIKIAN		